

Work Order ID 111123

Thursday, January 09, 2014 11:30:48 AM

111123

BFK

Page 1

Item ID: D3440-9

Accept

N900040100

Setup

Start *NS1*

Revision ID:

Item Name: Tube Detent Clip Base (Supersedes B67-43001-241)

Stop

NS2

Start Date: 1/9/2014 Start Qty: 10.00 *10*

Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 10.00 *10*

Customer:

Reference:

Approvals: Process Plan: MF

Date: 14-01-09

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3440	Rev A

100

100

BAND SAW

0.00

Bandsaw

Jeaspa Bandsaw

Memo

0.00

Cut blank: 1.250" x 1.250" x 1.825" long

MF 14/01/15

10 0

110

110

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

Machine as per Folio FA535 and Dwg D3440Dwg Rev: A Identify as
D3440-9Folio Rev: A Deburr

MF 14-01-21

MF 14/01/20

10 0

120

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

MF 14-01-21

MF 14/01/20

10 0

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Page 2

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Start Date: 1/9/2014 Start Qty: 10.00

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Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

DAS

130

QC

Quality Control

D.A. 14/01/21

10

6

08
9-89

140

Identify as per dwg & Stock Location: ST W4003 0.00***140***

Packaging

Packaging

10X 14-1-21

DAS
26
9-89

150

QC21- Final Inspection - Work Order Release 0.00

150

QC

Quality Control

PL 14/01/22

D 14/01/22

Picklist Print

Thursday, January 09, 2014 11:30:48 AM

Page 1

Work Order ID: 111123

Parent Item: D3440-9

Parent Item Name: Tube Detent Clip Base (Supersedes B67-43001-241)

Start Date: 1/9/2014

Required Date: 1/24/2014

Comments: IPP A05.06.30New issueKJ/JLM

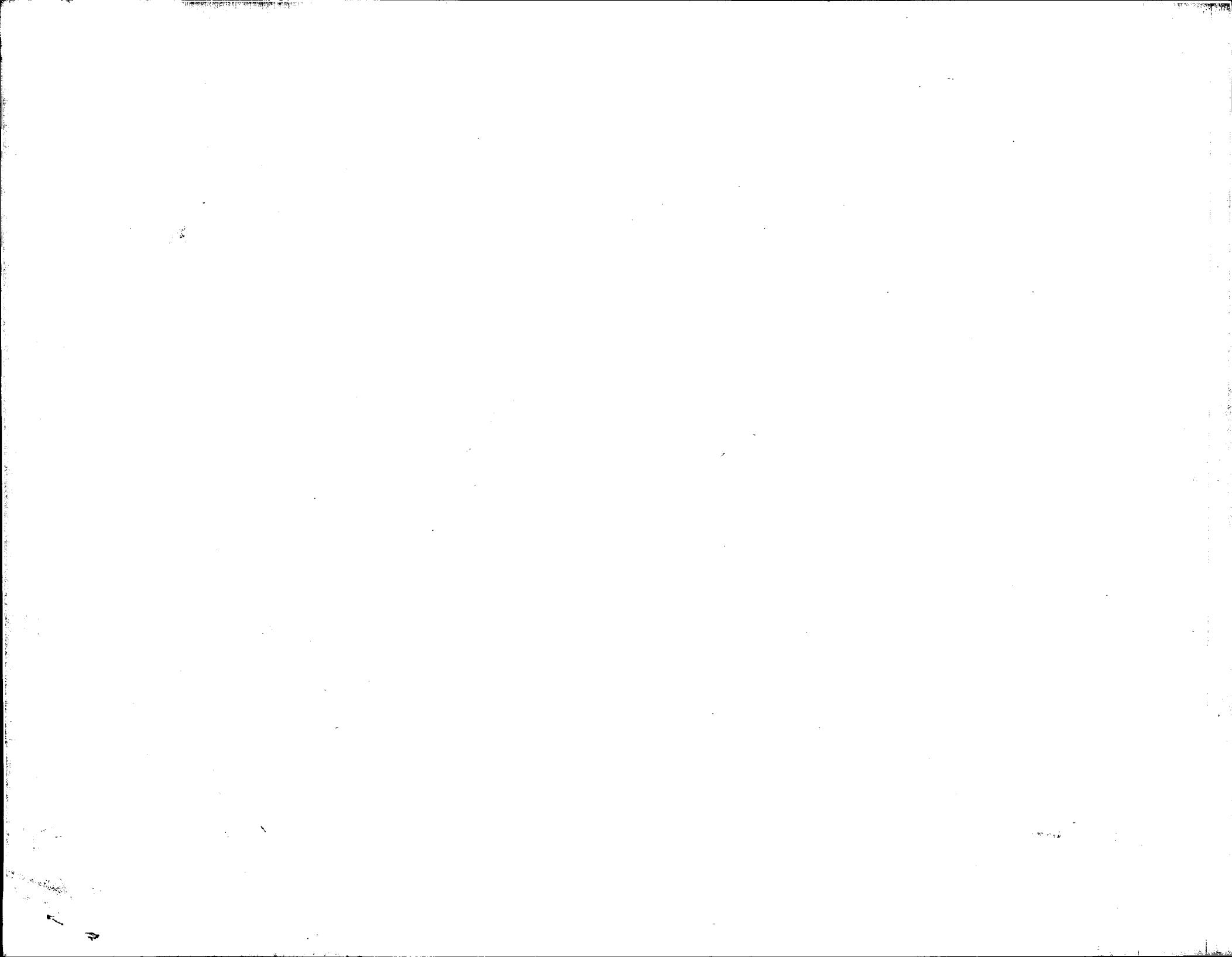
Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.250 6061-T6 Bar 1.25 x 1.25		Purchased		No		100	f	15.6250	0.1625	2			

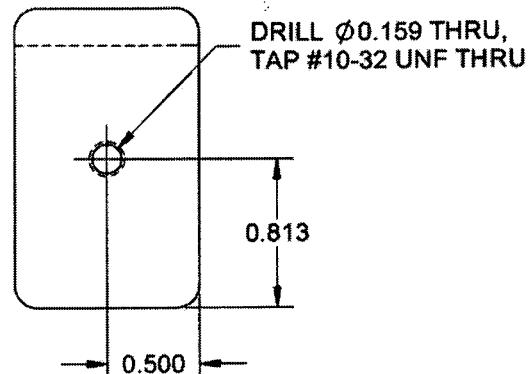
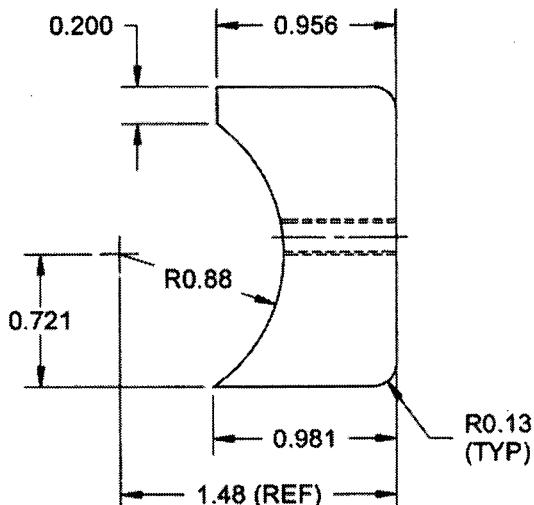
Location	Loc Qty	Loc Code	
MAT003	15.625		
→ 124443	3.625		
m126647	12		

1.6 14/01/15





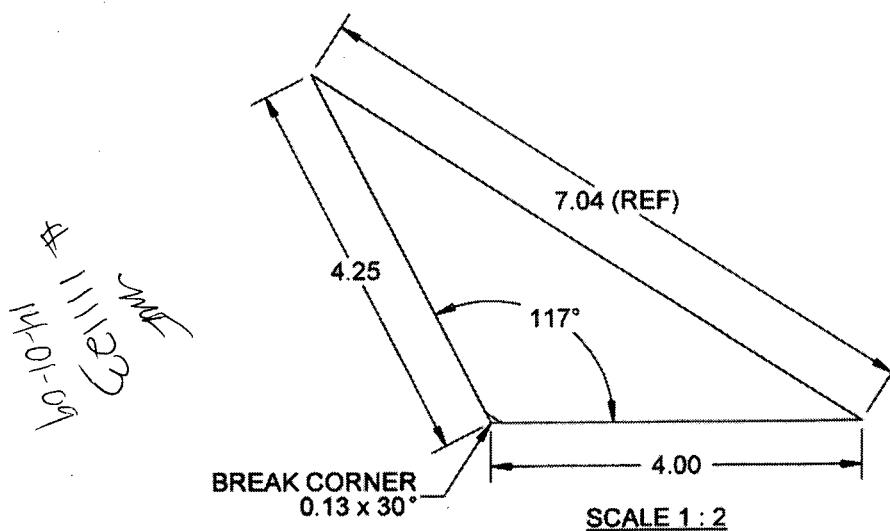
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3440	REV. A SHEET 5 OF 7
DATE	05.06.02	TITLE BLADE FOLD KIT PARTS	SCALE 1:1



D3440-9 TUBE DETENT CLIP BASE SUPERSEDES PREMIER P/N B67-43001-241

- 1) MATERIAL: 6061-T6 (OR 6061-651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)

*RELEASED
05/08/18*



D3440-11 GUSSET

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.250)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
NCR No. _____					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube	General	Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish Fit/Function	Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration Out of Sequence	Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other

DART AEROSPACE LTD	Work Order:	<u>111123</u>
Description: Tube Detent Clip Base	Part Number:	D3440-9
Inspection Dwg: D3440 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	F.K.	Audited by:	M.A. DAS 08	Prototype Approval:	N/A
Date:	14/01/20	Date:	14/01/21 8-89	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.09.19	New Issue	KJ/JLM	<i>[Signature]</i>

